

Date: Monday, 7/9/2007 11:47:01 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE -UNDER REVIEW CB 07.07.09		
Job Number	: 33360	Part Number	: D29382		
Estimate Number	: 10939	Drawing Number	: D2938 REV C		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 7/9/2007	S.O. No.	: N/A		
Prsht Rev.	: NC	Type	: MACHINED PARTS		
First Issue	: N/A				
Previous Run	: 32383				
Written By					
Checked & Approved By	: 07.07.09				
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length (D6101-003)	Batch No: B31387 JL 07/08/18 (20)
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 5-Deburr	JL 07/08/18 (20)
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	JL 07/08/18 (20)
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	JL 07/08/18 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

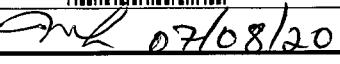
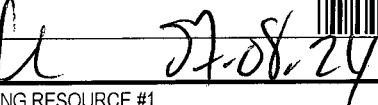
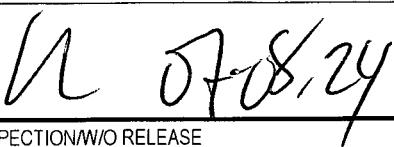
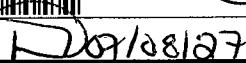
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/08/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW CB 07.07.09
Job Number: 33360		Part Number: D29382
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		 07/08/20 (20)
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		 07-08-24 (20)
7.0	POWDER COATING	POWDER COATING  M105068
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		 07/08/24 (20)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		 07.08.24
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		 07.08.24
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 07/08/27 (20)
Job Completion 		 07.08.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33360
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.122	.122	.123		
B	0.100	0.140		.126	.122	.122	.123		
C	0.100	0.140		.120	.119	.120	.121		
D	0.210	0.230		.219	.219	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.240	.239	.239	.239		
N	0.100	0.140		.116	.121	.122	.122		
O	0.540	0.560		.550	.549	.551	.550		
P	0.490	0.510		.499	.501	.500	.499		
Q	3.715	3.725		3.719	3.719	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.254	.251	.250	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.256	1.262	1.263	1.260		
Y	1.565	1.585		1.576	1.577	1.577	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	Audited by:	DR
Date:	07/08/18	Date:	07/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	DR

DART AEROSPACE LTD	Work Order:	333600
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.124	.123	.123	.123		
B	0.100	0.140		.124	.123	.123	.123		
C	0.100	0.140		.123	.122	.122	.123		
D	0.210	0.230		.221	.220	.220	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.2500	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.576	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.120	.121	.122	.122		
O	0.540	0.560		.550	.551	.550	.551		
P	0.490	0.510		.499	.500	.501	.498		
Q	3.715	3.725		3.720	3.719	3.719	3.719		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.251	.251	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.366	1.364	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.260	1.260	1.259	1.260		
Y	1.565	1.585		1.574	1.574	1.571	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	07/08/18

Audited by:	GNL
Date:	07/08/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	SPD

DART AEROSPACE LTD				Work Order:	33360
Description: 206 Saddle, Outboard, Right side				Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123	.123	.122	.124		
B	0.100	0.140		.123	.123	.122	.124		
C	0.100	0.140		.121	.123	.121	.121		
D	0.210	0.230		.219	.221	.220	.222		
E	1.245	1.255		1.250	1.256	1.250	1.250		
F	1.245	1.255		1.250	1.256	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.576	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.122	.123	.121	.120		
O	0.540	0.560		.551	.550	.550	.551		
P	0.490	0.510		.500	.501	.501	.502		
Q	3.715	3.725		3.720	3.719	3.719	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.252	.252	.253		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.261	1.260	1.261	1.261		
Y	1.565	1.585		1.572	1.574	1.574	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.	Audited by:	<i>[Signature]</i>
Date:	07/08/19	Date:	07/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	33360
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.121	.122	.121		
B	0.100	0.140		.121	.121	.122	.121		
C	0.100	0.140		.119	.119	.121	.120		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.576	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.499		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.239	.239	.239		
N	0.100	0.140		.122	.123	.122	.122		
O	0.540	0.560		.551	.551	.551	.551		
P	0.490	0.510		.500	.501	.502	.501		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.250	.251	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.261	1.262	1.260	1.261		
Y	1.565	1.585		1.574	1.573	1.573	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
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AG									
AH									
Accept/Reject									

Measured by:	JL	Audited by:	Onl
Date:	07/08/20	Date:	07/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	Onl

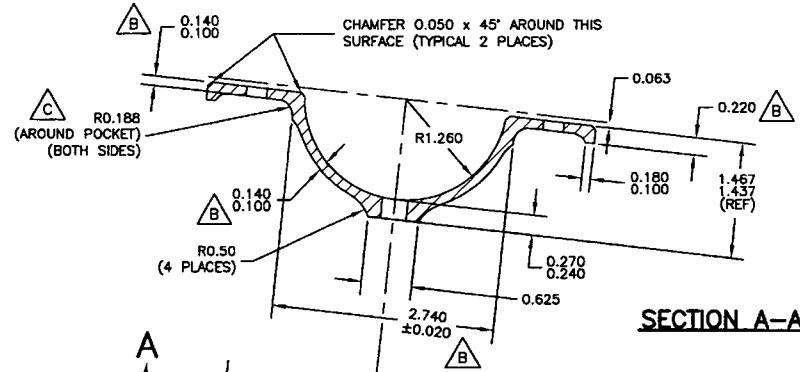
DART AEROSPACE LTD	Work Order:	33360
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

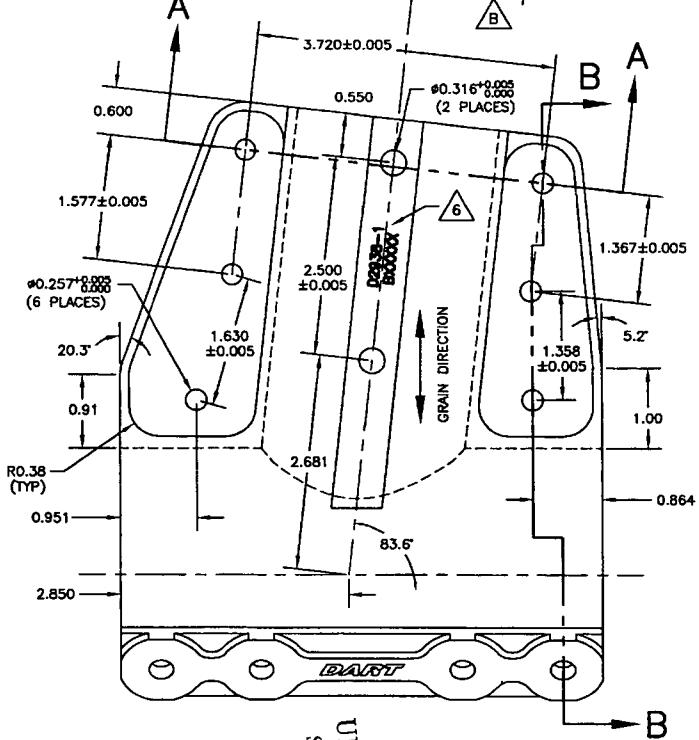
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.122	.120	.121		
B	0.100	0.140		.121	.122	.120	.121		
C	0.100	0.140		.120	.121	.119	.119		
D	0.210	0.230		.220	.222	.222	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.121	.121	.123	.121		
O	0.540	0.560		.551	.552	.551	.551		
P	0.490	0.510		.502	.502	.502	.500		
Q	3.715	3.725		3.719	3.719	3.720	3.719		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.252	.253	.250		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.629	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.261	1.263	1.263	1.260		
Y	1.565	1.585		1.575	1.574	1.575	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.	Audited by:	<i>Jml</i>
Date:	07/08/20	Date:	07/08/20

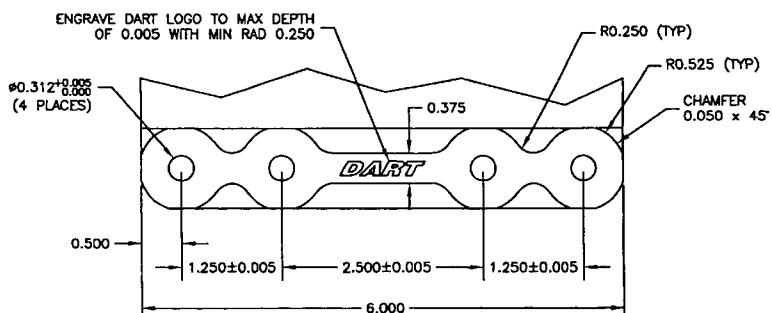
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JL</i>	<i>JML</i>



SECTION A-A



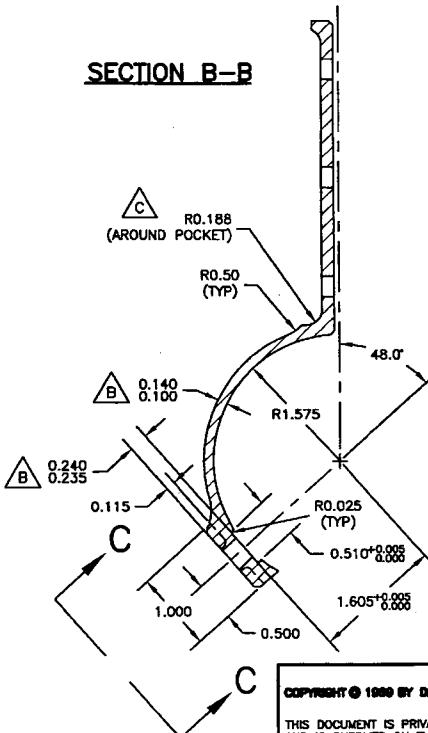
SECTION B-B



VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENgrave PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
C	06.11.09	R0.188 WAS R0.30 TO R0.25	
B	00.05.29	CHANGED GEOMETRY AND MATERIAL	
A	99.11.12	NEW ISSUE	
CHECKED	APPROVED	DRAWING NO.	REV. C
PJ		D2938	SHEET 1 OF 1
DATE	06.11.09	TITLE	SCALE
		SADDLE OUTSIDE	2:3

FROM ENGINEERING
07.02.02
NO. 3300
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
ENGINEERING
RETURN TO
SHOP COPY
NO. 3300